

NOTES:

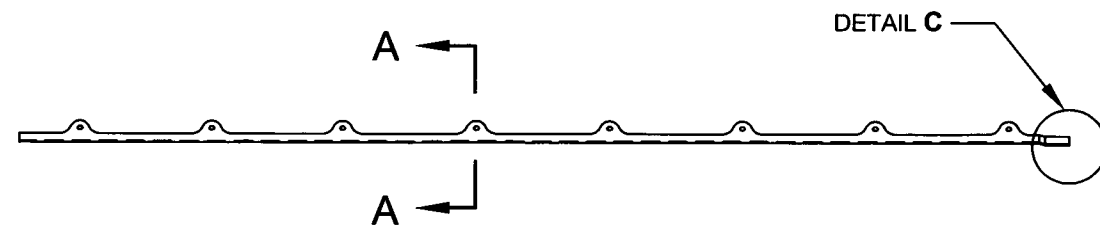
- 1) MATERIAL: MAKE FROM -1F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE 1A3
- 8) APPLY HARD SURFACING WELD BEAD 0.06 - 0.13 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR
APPLY HARD SURFACING WELD BEAD 0.06 - 0.13 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)

WEIGHTS:

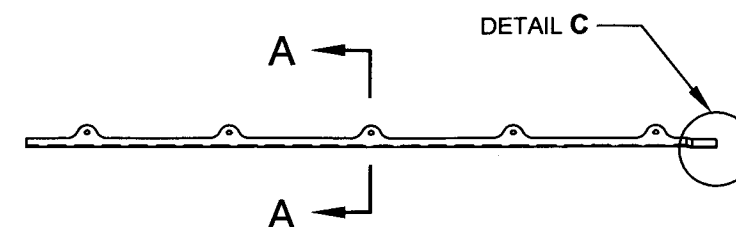
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

PRELIMINARY

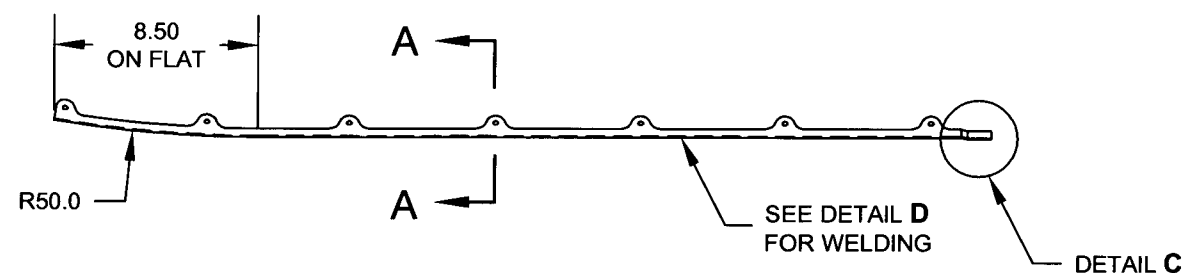
E	WELDING NOTE REVISED FOR AUTOMATED WELDING FINISHED REMOVED GENERAL UPDATE TO CURRENT STANDARDS	AJS	15.10.07
D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8, PG3 B5,C5: ADD D3564-15; PG1 B6,B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ON PG1; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5,7,B2: RELOCATE DETAILS AND SECTION; PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A.P.	DRAWING NO. REV. E1	
MFG. APPR.	DA	D3564 SHEET 1 OF 5	
APPROVED		TITLE SCALE	
DE APPR.		WEARSHOE NTS	
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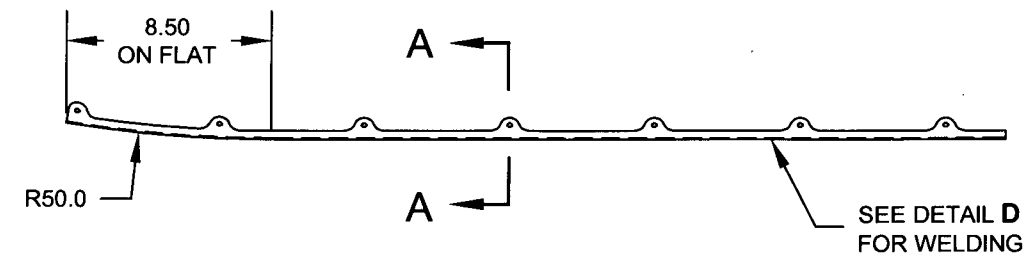
D3564-5 WEARSHOE
BENDING DETAIL
(MAKE FROM D3564-5F)



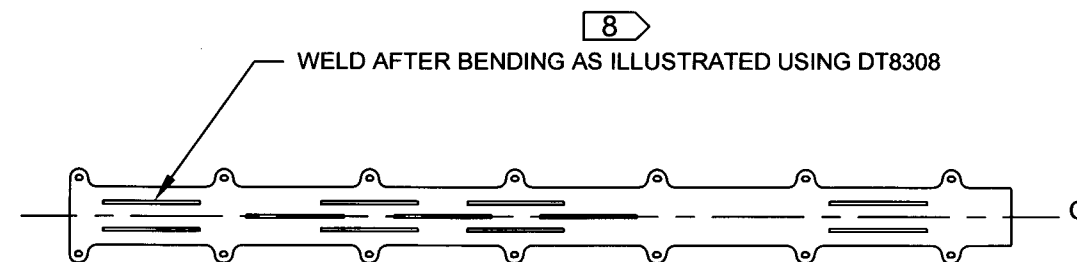
D3564-7 WEARSHOE
BENDING DETAIL
(MAKE FROM D3564-7F)



D3564-9 WEARSHOE
BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-11 WEARSHOE
BENDING DETAIL
(MAKE FROM D3564-1F)

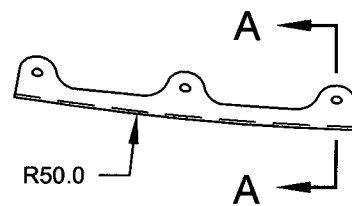


DETAIL D
(D3564-1/-3/-9/-11 WELDING DETAIL)

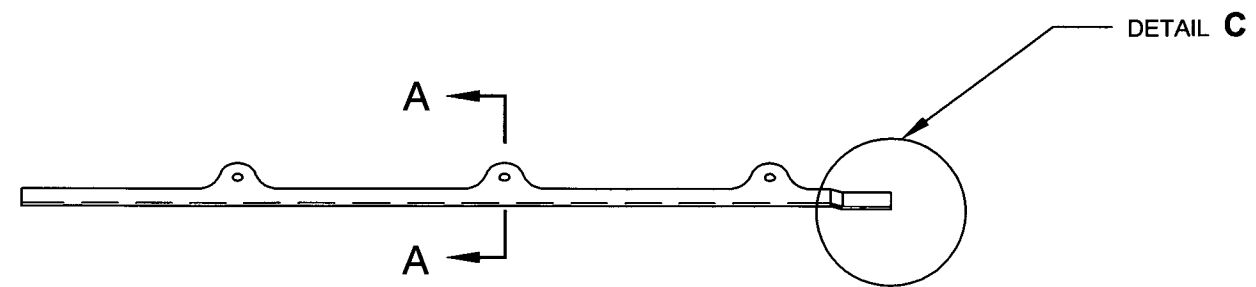
NOTES:

- 1) MATERIAL: MAKE -5 FROM -5F
MAKE -7 FROM -7F
MAKE -9, -11 FROM -1F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE 1A3
- 8) APPLY HARD SURFACING WELD BEAD 0.06 - 0.13 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR
APPLY HARD SURFACING WELD BEAD 0.06 - 0.13 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)

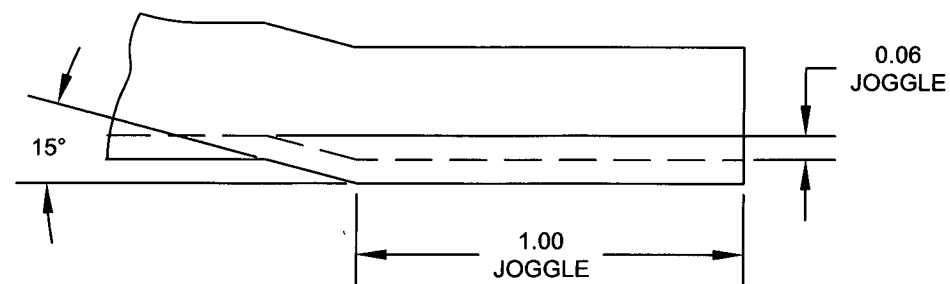
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. <i>[Signature]</i>
MFG. APPR.	<i>[Signature]</i>	D3564	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEARSHOE	NTS
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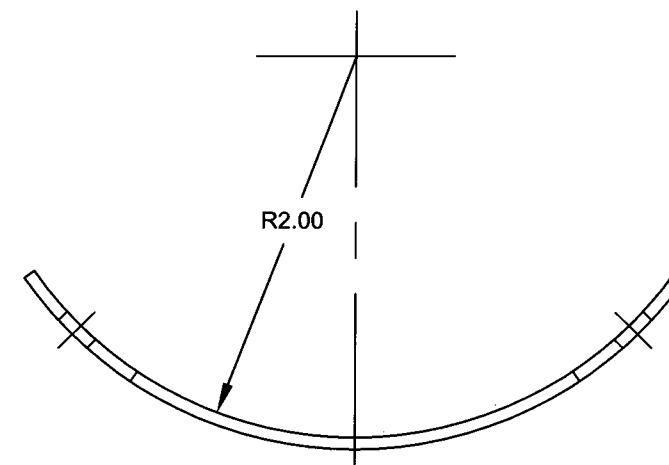
D3564-13 BENDING DETAIL
(MAKE FROM D3564-13F)



D3564-15 BENDING DETAIL
(MAKE FROM D3564-15F)



DETAIL C
SCALE 4X



SECTION A-A
SCALE 4X

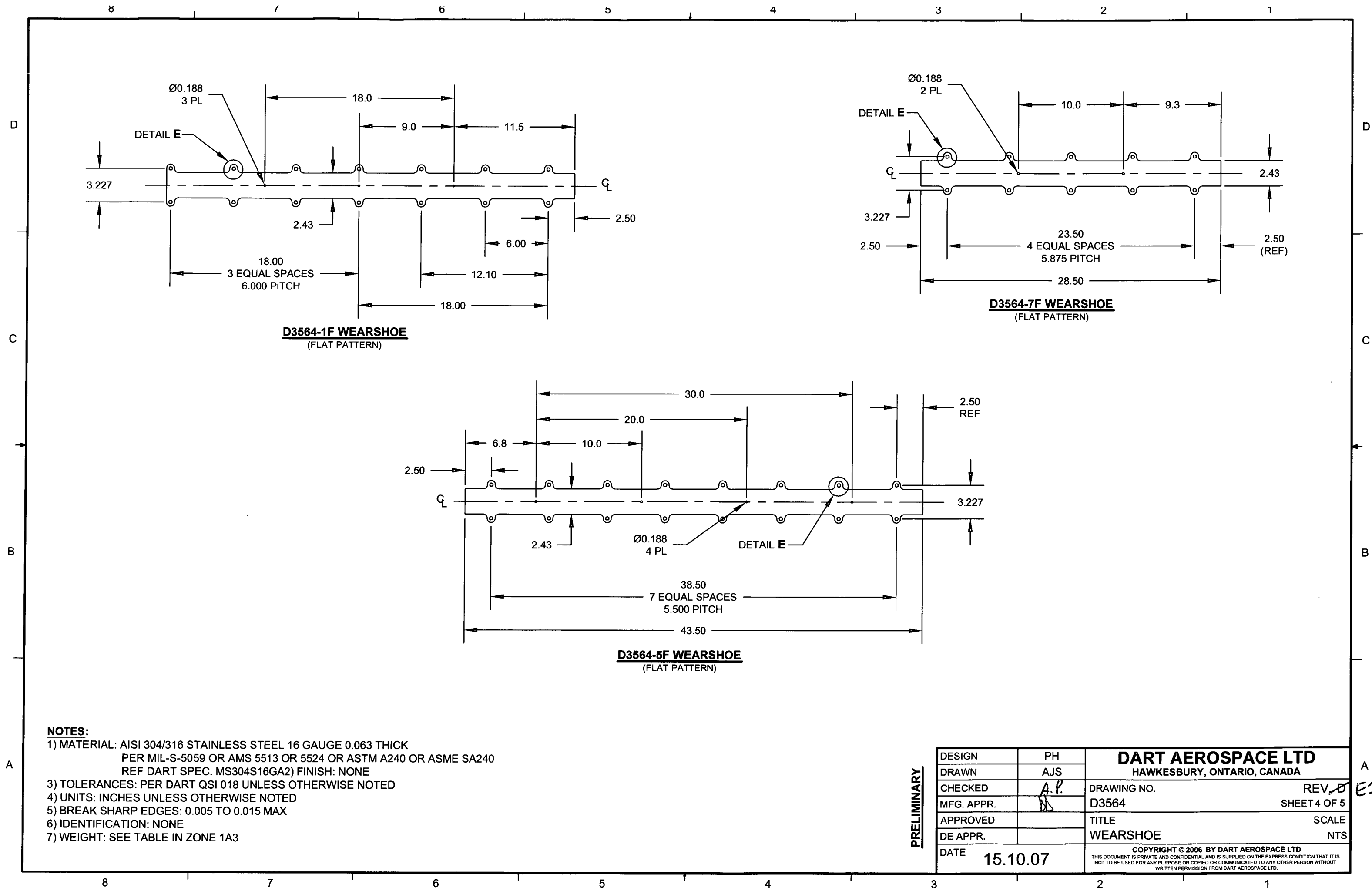
NOTES:

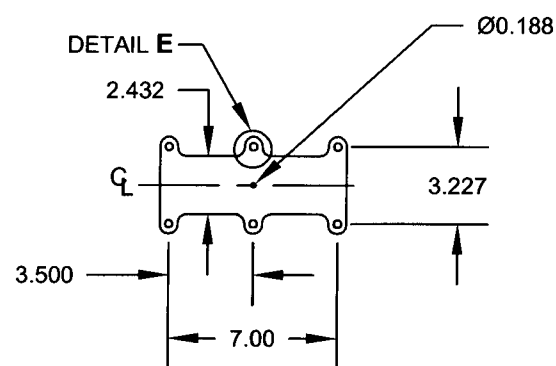
- 1) MATERIAL: MAKE -13 FROM -13F
MAKE -15 FROM -15F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE 1A3

PRELIMINARY

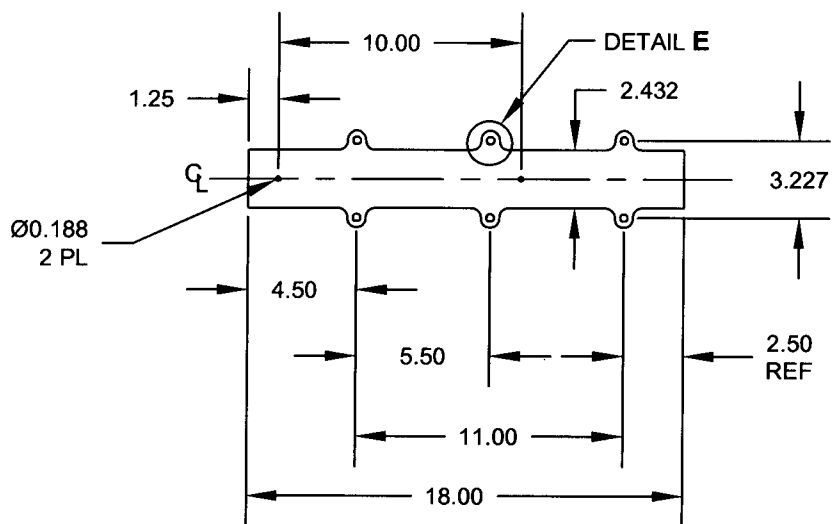
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A.P.	DRAWING NO.	REV. <i>D</i>
MFG. APPR.	<i>AS</i>	D3564	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEARSHOE	NTS
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A
E1

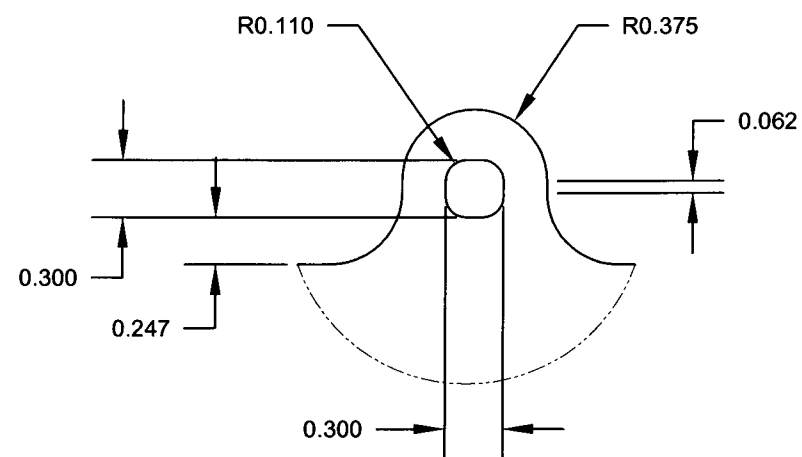




D3564-13F WEARSHOE
(FLAT PATTERN)



D3564-15F WEARSHOE
(FLAT PATTERN)



DETAIL E
SCALE 1:1

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 16 GAUGE 0.063 THICK
PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF DART SPEC. MS304S16GA2) FINISH: NONE
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 5) IDENTIFICATION: NONE
- 6) WEIGHT: SEE TABLE IN ZONE 1A3

PRELIMINARY

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A.P.	DRAWING NO.	REV. E1
MFG. APPR.	M.S.	D3564	SHEET 5 OF 5
APPROVED		TITLE	SCALE
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